

Work Order ID 72327



Friday, July 22, 2011 11:34:45 AM

Page 1

Item ID: D3414-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 7/22/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:	Process Plan:	CL	Date:	11/07/22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:		Stop		

Run Start



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev C								

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut blanks: 2.50" x 0.500" x 2.250" long

0.00
art/FK. 11/07/27 40 Ø

110



HAAS I
HAAS CNC vertical machine #1

punch

Memo

Machine as per Folio FAS69 and Dwg D3414
Identify as D3414-3 Dwg Rev Folio Rev

0.00
Issue P.D 14572

0.00
Dn's Precision

Machine per drawing D3414 Rev C

11/08-04

120



QC
Quality Control

PLD
PLD

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

Receive & Inspect for transit damage
Ensure CofC attached

CD 11/08/23 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: Lug

Stop



Start Date: 7/22/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 8/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S 108/24

Locate
74/0

140



Packaging

Packaging

Identify as per dwg & Stock Location: W/A

0.00

Memo

030

0.00

11-8-2011 (X-15)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/2011 (X-15)

C 11/10/2011

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 11:34:42 AM

Page 1

Work Order ID: 72327



Parent Item: D3414-3



Parent Item Name: Lug

Start Date: 7/22/2011

Required Date: 8/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500 304 BAR .500 x 2.50		Purchased		No		100	f	20.7750	0.1875	7.5		F.K. 11/07/27	

Location	Loc Qty	Loc Code
MAT050	20.775	
112764	16	7.688
116135	0.375	
117685	4.4	

D3414-3 P

X 40

C 11/08/23

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

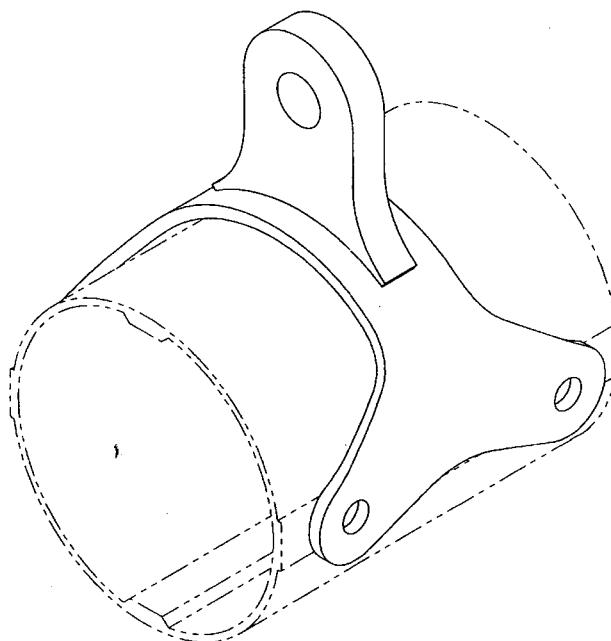
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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8 7 6 5 4 3 2 1

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

8 7 6 5 4 3 2 1

C L1107122
W10.72327

RELEASED
21/08/2014

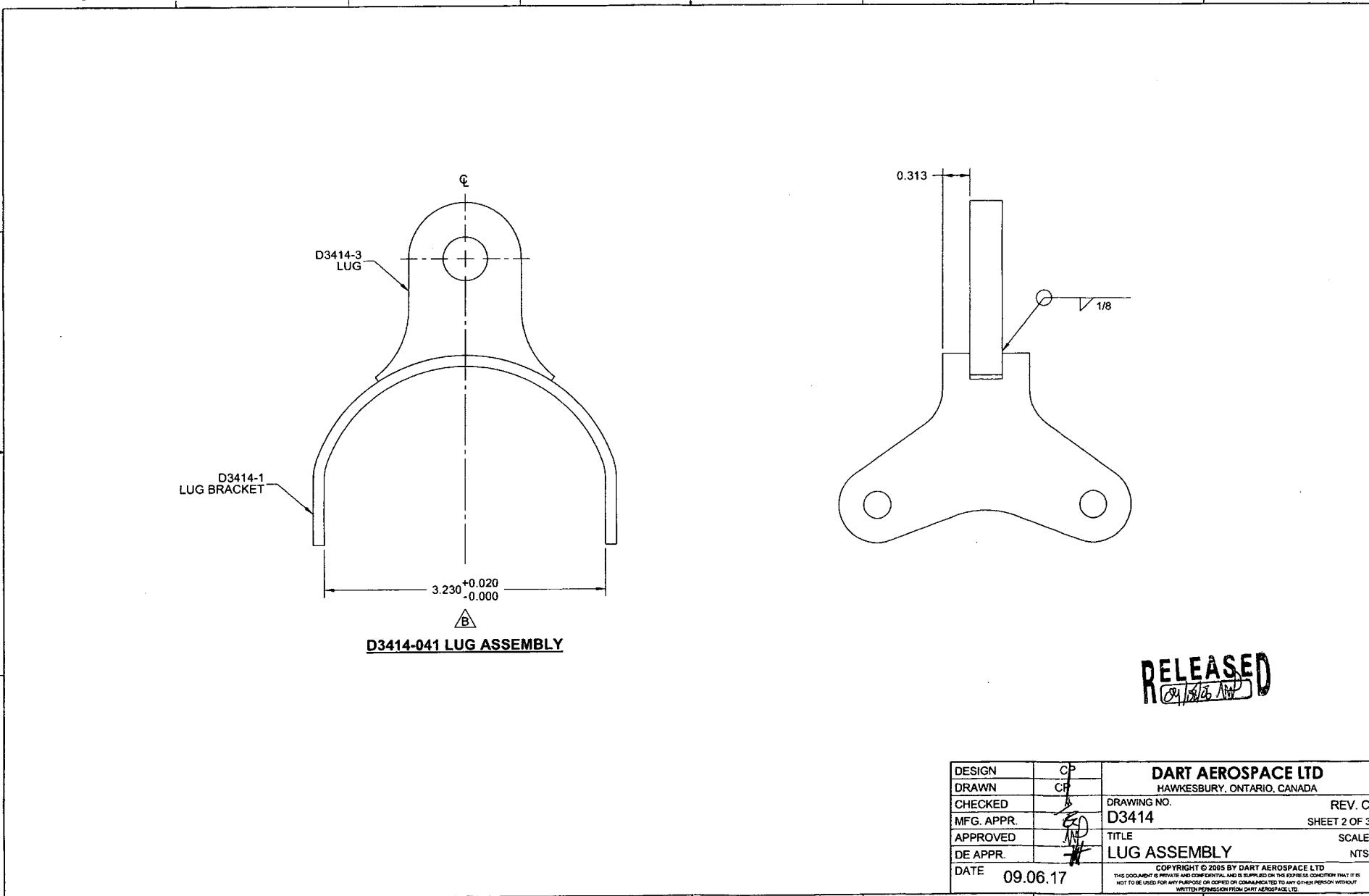
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)		CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.		AJS	08.09.23
A	NEW ISSUE		CP	05.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CP	DRAWING NO.	REV. C D3414 SHEET 1 OF 3	
CHECKED		MFG. APPR.	APPROVED DE APPR.	
APPRAVED		DATE	TITLE LUG ASSEMBLY SCALE NTS	
DE APPR.		09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED, OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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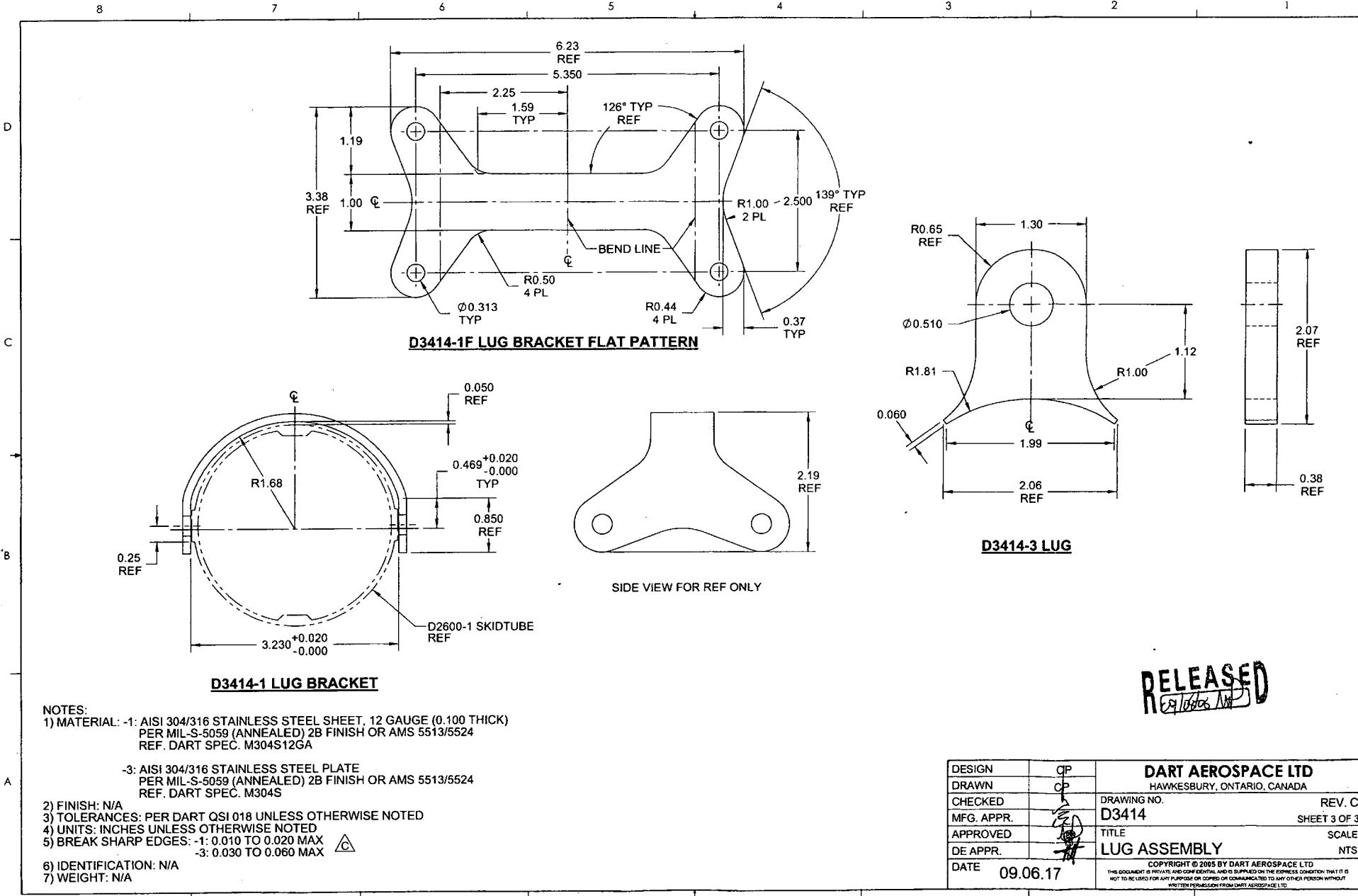
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

C

B

A

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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A-3HO
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

PACKING SLIP

Ship To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Number: 10677

Date: August 23, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	1	60	D3404-1revC	GHW Lug	Complete
2	2	40	D3414-3revC	Lug Assembly, Lug	Complete

CS 11108123

Number of Packages:	<input type="checkbox"/> Boxes _____
	<input type="checkbox"/> Bags _____
<input type="checkbox"/>	<input type="checkbox"/> Bundles _____

Received by: _____ Date: _____

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 23-Aug-11
Purchase Order : PO14572
Packing Slip : 10677
Part Number : D3414-3revC
Quantity : 40

S. Worley

Per: _____

[Signature]
For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14572

W/O: _____

Part #: D3414-3 rev C

Lug Assembly, Lug

Qty: 40

1 of 1